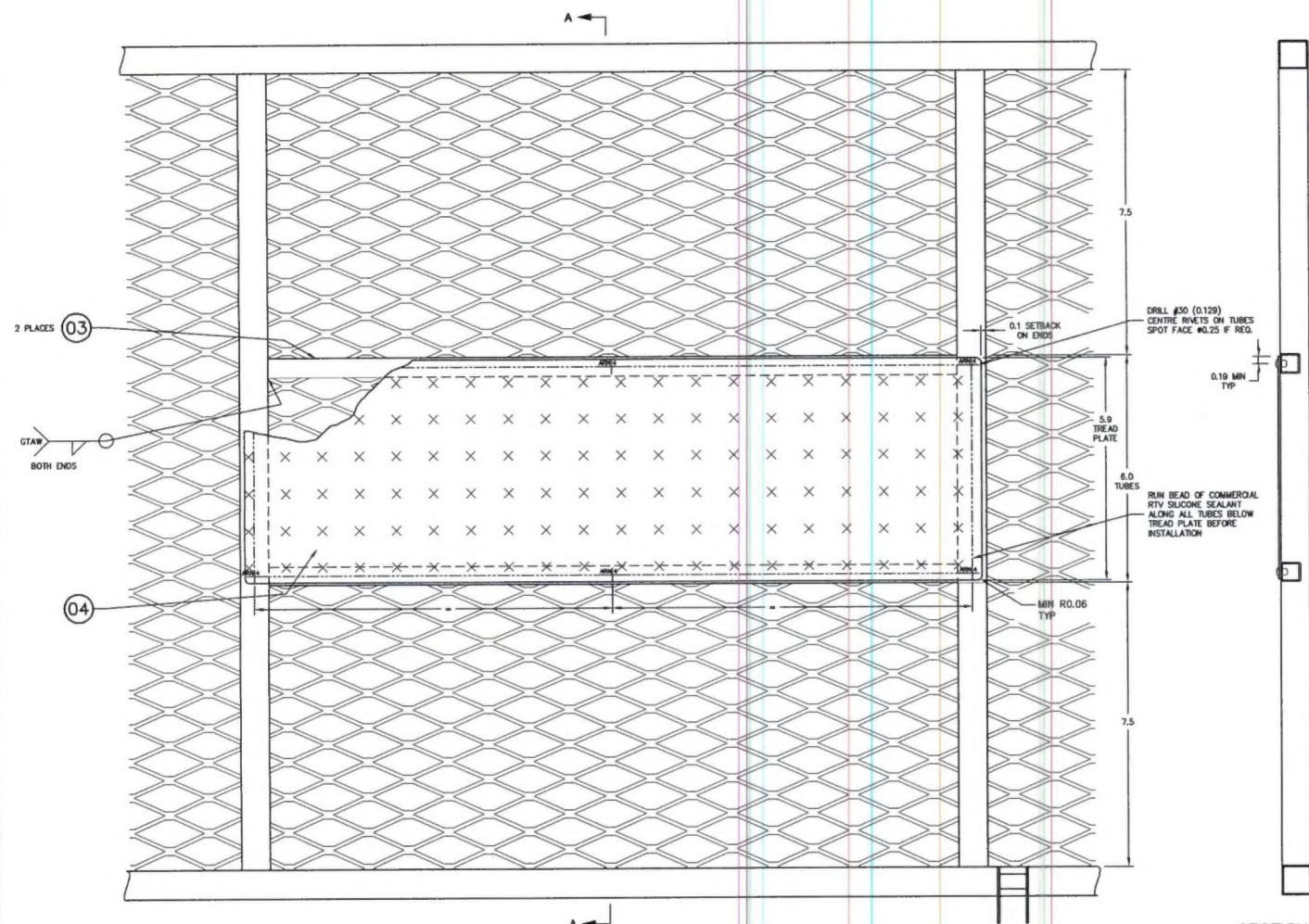


2017-140



(01) BASKET LID ASSEMBLY

SECTION A-A

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

NOTES:

- THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
- TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
- WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	ML-T-6736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS		

BASIC CODE REF. HAS 503	DASH NO. FOR DIAMETER N=INFD. HEAD NEAR SIDE F=INFD. HEAD FAR SIDE	DASH NO. FOR LENGTH	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGOIN	DATE 21 SEPT 2006
C=COUNTERSUNK D=DIMPLE DIGIT # OF SHEETS TO BE DIMPLED			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARM=CR3213 ARM=CR3212	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET + EXISTING RIVET			

AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 804.685.5076 www.aerodesign.ca			
CARGO BASKET LID STEP MODIFICATION			
SCALE 1: 1.5 SHEET 1 OF 1	DWG. SIZE A1	DWG. NO. 70405	REV. 4

Bell 429 R/H X (2)

CARGO BASKET LID FABRICATION - COMMON

2017-140

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket



Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2017-140

Date Open: Aug 17/2017

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

3. Inspection

- Rim for complete welds

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

7. Inspection

- Frame assembly for complete welds.

AD
73-04
05

AD
73-04
05

AD
73-04
05

AD
73-04
05

AD
73-04
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AD
73-04
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73-04
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73-04
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73-04
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73-04
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AD
73-04
05

AD
73-04
05

CARGO BASKET LID FABRICATION

Complete

(initial or SCA #)

8. Mesh assembly.

NA

NA

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

NA

NA

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

AD
73-04
05

AD
73-04
05

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lid prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

JC

JC

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- ~~Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.~~
 - ~~3 places for lids under 76"~~
 - ~~4 places for lids over 76"~~
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

JC

JC

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

AD
73-04
02

AD
73-04
02

Work Order: 2017-140

Material Tracking Sheet

1 of 2

Date Opened: Aug 17/2017Bell 429 - Post 81
Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			95912-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97.0")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17004
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17004
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	17004
Step 5	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	17038
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2016-147
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R		--	Welding Rod	ER308L TIG Rod	17066
	. 1		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	17066

Work Order: 2017-140

Material Tracking Sheet
Bell 429 - Post 81
Lid Fabrication

2 of 2

Date Opened: Aug 17/2017

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 11				Clean Up		
Step 12				Inspection - Final Assembly		
Step 13				Powder Coating		17085 / 17097



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Hoop

No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 95964-01/94522-01 Serial / Batch No.: 15072

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2016-41

Remaining Tasks to be Performed: Provisions to be machined

Signature: Dw Bell

Date: March 21st/2016

Lic. No. / SCA AD-07

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L407 Hopp/Hurdle No. of pieces: 1

Manufacturer: _____

Part No.: 94520-01 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 205-01

Remaining Tasks to be Performed: weld into basket

Signature: KCrawen

Date: March 10, 2015 Lic. No. / SCA _____

Form# 20.E.03

Rev. 1 24 April 2014

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Hoop

No. of pieces: _____

Manufacturer: Aero Design Ltd.

Part No.: 95964-01/94522-01 Serial/Batch No.: _____

TTSN: N/A TSO: N/A Rem.: _____

Work Order No.: 2016-41

Remaining Tasks to be Performed: _____

Signature: Dan B.

Date: Mar 21st/11

Lic. No. / SCA _____

Form# 20.E.03

Rev. 1 24 April 2014

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 206L/407 Hoop - Handle No. of pieces: 1

Manufacturer: _____

Part No.: 94520-01 Serial / Batch No.: _____

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2015-25

Remaining Tasks to be Performed: weld into bracket

Signature: K. Cramen

Date: March 10, 2015 Lic. No. / SCA _____

In Process

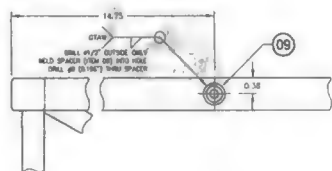
$$R/H \times 2$$

The drawing consists of three views of a window assembly:

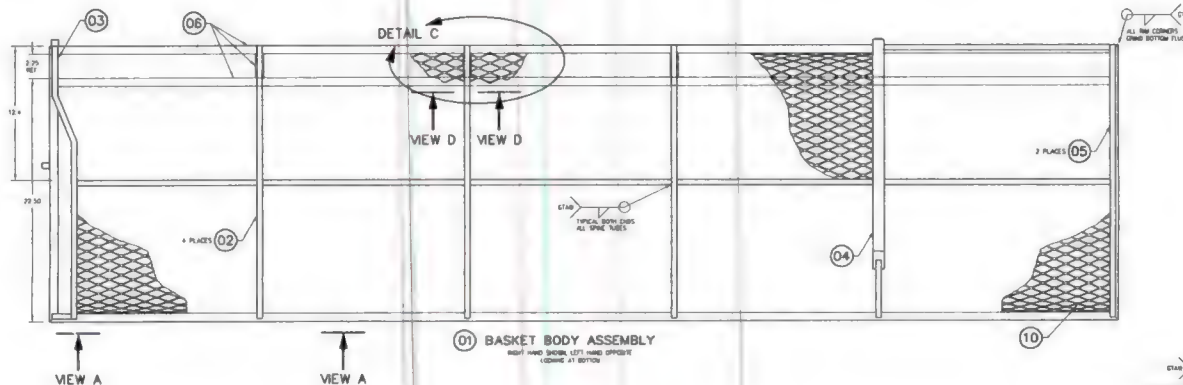
- View D6 (Top View):** Shows a rectangular frame with a diagonal mullion. Dimensions include 25.5 and 24.25 for the top width, and 17.50 for the height. A circular feature is labeled 'B'. A note indicates 'NO MULLION TRIM END (1 SIDE ONLY)' and 'BOTH ENDS' with a dimension of 11.40.
- View D5 (Side View):** Shows the profile of the window frame. Dimensions include 18.50, 3.7, 18.88 REF, 18.88 REF, 18.50 REF, and 21.25 REF. A note indicates 'THIS END ONLY'.
- View F (Front View):** Shows the front elevation of the window. Dimensions include 18.50 REF, 18.38 REF, 18.38 REF, 17.75 REF, and 20.50 REF. A note indicates 'VIEW F'.

NOTES

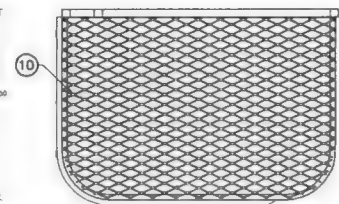
1. REAMER: ALL BORES AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS D9.8DC.
4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
STAINLESS STEEL AND 4130 WELDING ROD SHALL CONFORM TO ER308 OR EQUIVALENT
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSINITE WELD
4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUSPENSION PRIOR TO ASSEMBLY



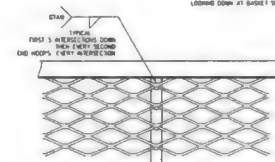
SCALE 1:1
VIEW LOOKING AT FRONT END OF BRIDGE



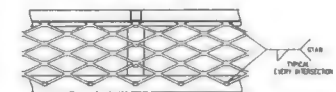
RIGHT HAND SHOWN, LEFT HAND
LOOKING AT BOTTOM



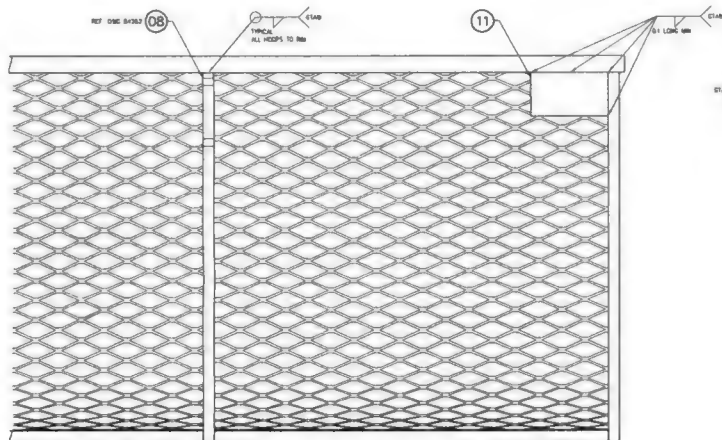
VIEW F
SCALE 1/2"
LOOK DOWN AT BACK OF VIEW



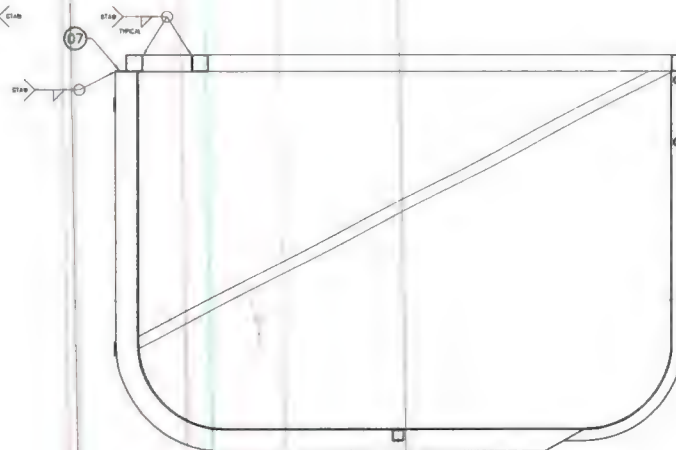
VIEW D
SCALE 1:2
FOR LADING AT BASKET HOOP



DETAIL C
VIEW LOOKING UP AT BASKET FROM
SCALE 1:3



VIEW A
SCALE 1:2
VIEW LOOKING AT FORWARD OUTBOARD SIDE OF BULKHEAD



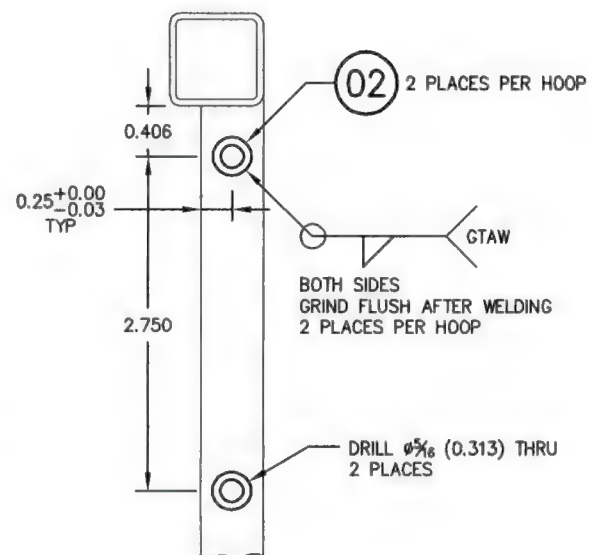
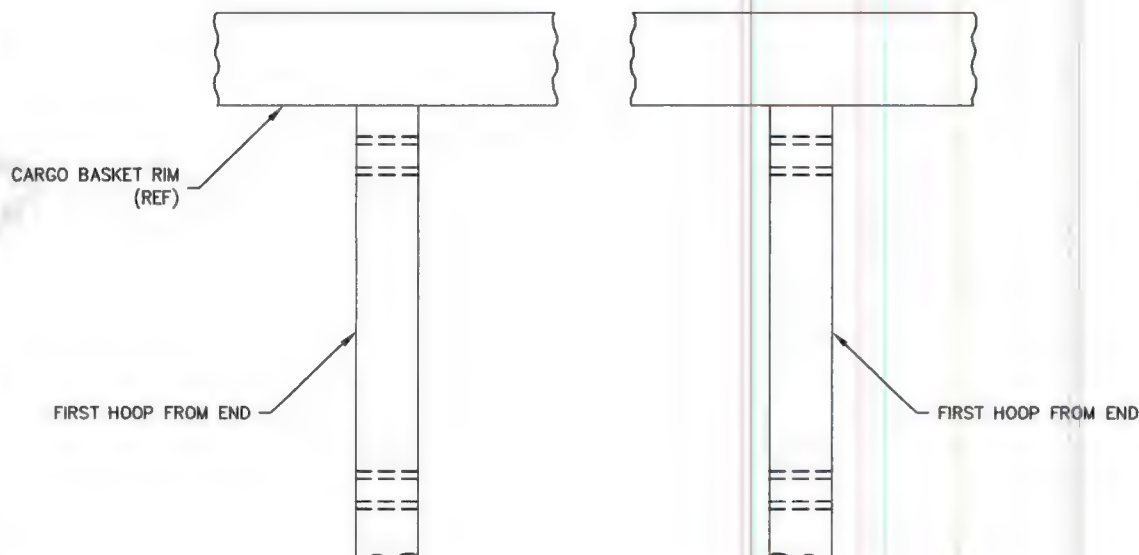
SECTION E-E
SCALE 1/2"
VIEW LOOKING FROM THE SOUTH

[illegible]

2017-140

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE -- CREATED FROM 36262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE IJD PROVISIONS TO 84263	BJC	14/02/2014



(01) BASKET HANDLE PROVISIONS ASSEMBLY PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

NOTES:

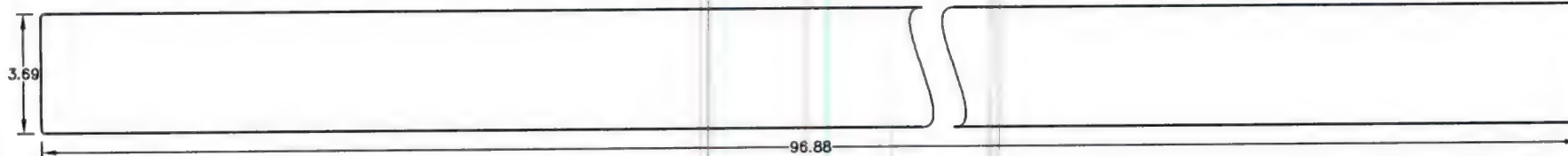
1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY
01	PART NO.	ITEM	DESCRIPTION
QTY	LIST OF MATERIALS		

APPROVALS		DATE	
DRAWN:	JEFF CLARKE	03 NOV 2009	
CHECKED:	E. BURGAIN		
<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</p> <p>DECIMALS ANGLES</p> <p>X.XXX ±0.010 ±1/2°</p> <p>X.XX ±0.03</p> <p>X.X ±0.1</p>			
<p>AERO DESIGN LTD.</p> <p>9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.485.5276 www.aerodesign.ca</p>			
<p>HELICOPTER CARGO BASKET BASKET HANDLE PROVISIONS ASSEMBLY</p>			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2

2017-140


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



03 FILLER SHEET

NOTES

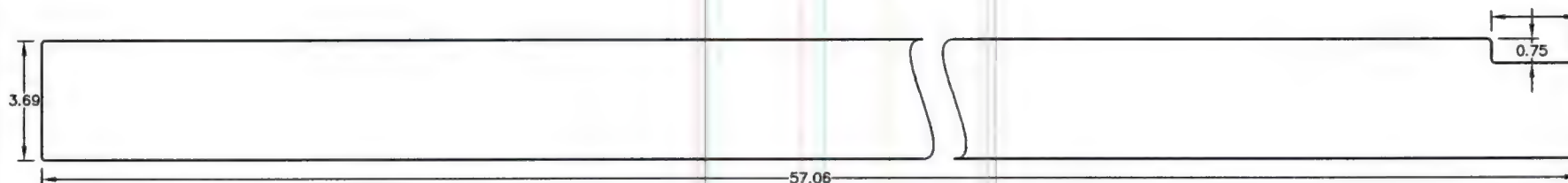
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

1	95916-03	01	FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET	
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
NOTICE THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.				APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 09 NOV 2012 10 NOV 2012	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca	
				SCALE 1 : 4 SHEET 2 OF 2		DWG. SIZE LGL	
				DWG. NO. 95916		REV. 1	

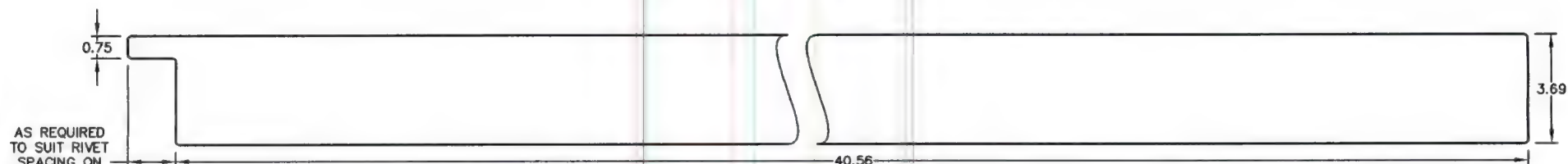
 BELL 429
 QUICK RELEASE CARGO BASKET
 FILLER SHEET

2017-140

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



① FORWARD FILLER SHEET




② AFT FILLER SHEET

1	95916-02	02	AFT FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
1	95916-01	01	FORWARD FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 09 NOV 2012 10 NOV 2012		 <p>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca</p>
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				
	BELL 429 QUICK RELEASE CARGO BASKET FILLER SHEET				
	SCALE 1 : 4 SHEET 1 OF 2	DWG. SIZE LGL	DWG. NO. 95916	REV. 1	

Bell 429 R/H

CARGO BASKET BODY FABRICATION - COMMON

WO# 2017-140

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket



Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2017-140

Date Open: Aug 17/2017

AD
73-04
05

AD
73-04
05

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD
73-04
05

AD
73-04
05

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD
73-04
05

AD
73-04
05

3. Inspection

- a. Rim for complete welds

AD
73-04
05

AD
73-04
05

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 1. Attachment lugs are on inboard side.
 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

6. Inspection

- a. Frame assembly for complete welds.

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

8. Weld mesh to frame assembly per drawing.
- Ensure lug locating jig is in place prior to welding.
 - General welding requirements for all baskets, MIG welding:
 - Every intersection at top edges.
 - Every intersection at ends.
 - First 5 intersections down on hoops, then every second intersection.
 - Every intersection along spine.
 - Extra large baskets – every intersection along corner.
 - Every intersection around ends
 - Every intersection along struts (if applicable)
 - Bend and trim cells bent in to fit mesh as required and weld in position.
 - Grind high spots off body mesh welds on ends before welding end mesh.
 - 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - Record welding rod PO on attached material list.

9. Weld basket components

- TIG weld lid prop bushing(s), one or two per drawing.
 - Record welding rod PO on attached material list.
 - Record lip prop bushing WO on attached material list.
- TIG weld caps to close top of 1" hoops as applicable.
- 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - Cut inboard rim on aft end. Grind flush with hoops.
 - TIG weld caps on open tubes.
 - Record cap material PO on attached material list.
- 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - Record welding rod PO on attached material list.
 - Record placard bracket WO on attached material list.

10. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- ~~Drill #9 through lid prop bushing(s). De-burr hole(s).~~
- Remove surface rust with scotch-brite pad.

11. Final Inspection

- To be completed by a different person than the previous steps.
- Basket body assembly for complete welds, and required minimum mesh weld locations.
 - Filled vent holes – usually on hoops
 - Overall condition and conformity to drawing(s).
 - Hoops for height.
 - Rim for width and length and alignment.
 - Lid prop lugs in correct ends.
 - Fore/aft strut in hoop if required by drawing.
 - Material lists complete.

CARGO BASKET BODY FABRICATION - COMMON

Complete

(initial or PO #)

AD
73-04
02

73-04
02

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2017-140Date Opened: Aug 17/2017Material Tracking Sheet
Bell 429 - Post 81
Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		<u>95951-01-01</u>	Basket Body Assembly	<u>(-01 RH, 02 LH)</u>	
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>2017-83</u>
	. 1		--	3/4" Tube - Long stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
	. 4		--	3/4" Tube - Short Rim (2.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14009</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>16078</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 3		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
	. 1	84262	94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u> <i>295-01/295-25</i>
	. 1		95964-01	Forward Attachment Hoop		<i>See attached</i>
	. 1		95926-01	Aft Attachment hoop - with handle provisions		<i>See attached</i>
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
	. 1		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>16078</u>
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	<u>16009</u>
	. 1		--	Mesh (End - 24.75" x 16.75")	3/4-16F Expanded Mild Steel sheet	<u>17025</u>

Work Order: 2017-140Date Opened: Aug 17/2017Material Tracking Sheet
Bell 429 - Post 81
Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mesh</i>		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	16078
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 9.b.	1		--	Cap	1018 Mild Steel, 0.032" Sheet	2019
	A/R			Welding Rod	ER70S-2 TIG Rod	16078
Step 9.d.	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2016-119/2014-81
	A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 10				<i>Clean Up</i>	None	
Step 11				<i>Inspection - Final Assembly</i>	None	
Step 12				Powder Coating		17055 / 17097

Work Order: 2017-140Date Opened: Aug 17/2017Material Tracking Sheet
Bell 429 - Post 81
Hoops Fabrication

1 of 2

(2) R/H

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	<u>6</u>		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	4083 17038
Step 1	<u>2</u>		94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	2015-01/2015-25
Step 2		84262		Welding		
	. 2		84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	2016-134 Jc.
	A/R		--	Welding Rod	ER70S-2	16078 Jc.
Step 3				Inspection	None	
	<u>2</u>		95964-01-01	Hoop - attachment (forward) (-01 RH, -02 LH)		
Step 1				Fabrication		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	2016-41
Step 2				Welding		
	. 1		95925-02	Lug	1018 Steel, 5/8" Rod	2015-108
	. 1		95925-03	Lug	1018 Steel, 5/8" Rod	2015-108
	A/R		--	Welding Rod	ER70S-2	16078
Step 3				Inspection and Finishing	None	

Work Order: 2017-140

Material Tracking Sheet

2 of 2

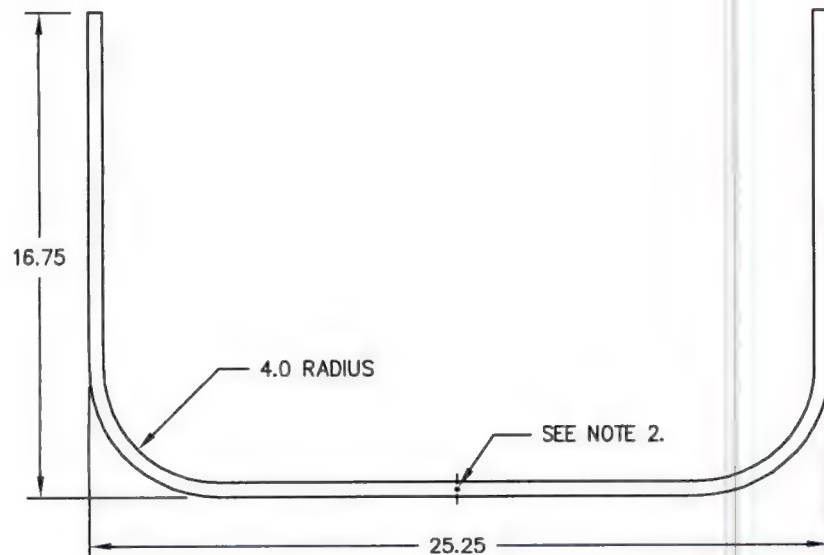
Date Opened: Aug 17/2017

Bell 429 - Post 81

Hoops Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>2</u>		95926-01	Hoop - attachment (aft)		
Step 1				<i>1/2 Hoop Fabrication - 1/2" hoop</i>		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038</u>
Step 2				<i>Machining</i>	<i>None</i>	
Step 3				<i>1/2 Hoop Fabrication - 1" hoop</i>		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	<u>17038 40"</u>
Step 4				<i>Machining</i>	<i>None</i>	
Step 5				<i>Joint Preparation</i>	<i>None</i>	
				<i>Welding</i>		
Step 6	. 1		95926-04	Lug	1018 Mild Steel, 5/8" Dia.	<u>12056</u>
	. 1		95926-05	Lug	1018 Mild Steel, 5/8" Dia.	<u>12056</u>
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	<u>2016-134</u>
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	<u>15035</u>
	. A/R		--	Welding Rod	ER70S-2	<u>16078</u>
Step 9				<i>Finishing and Inspection</i>	<i>None</i>	

2017-140




(01) HOOP

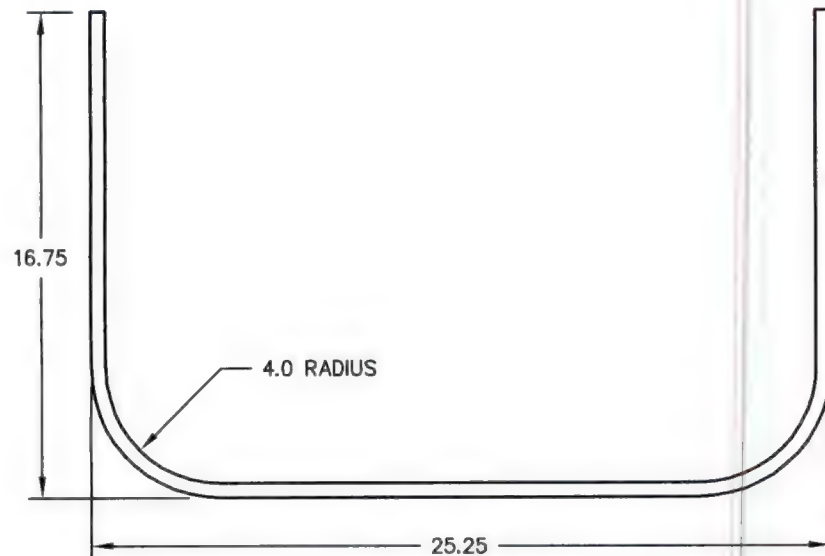
NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK	BJC	10/04/2014

94520-01		01	END HOOP		4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE	
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC		STOCK SIZE
QTY	LIST OF MATERIALS							
<div>NOTICE</div> <div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DISSEMINATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</div>			APPROVALS		DATE		<div></div> <div>AERO DESIGN LTD.</div> <div>9888A MALASPINA ROAD</div> <div>POWELL RIVER, BC, CANADA, V8A 0G3</div> <div>TEL: 604.483.2376 www.aerodesign.ca</div>	
			DRAWN: JEFF CLARKE		13 SEPT 2011			
			CHECKED: E. BURGAIN					
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				<div>BELL 206L SERIES, 407</div> <div>QUICK RELEASE CARGO BASKET</div> <div>HOOP</div>	
DECIMALS		ANGLES						
X.XXX ±0.010		±1/2°						
X.XX ±0.03				SCALE 1 : 5		DWG. SIZE		DWG. NO.
X.X ±0.1				SHEET 1 OF 1		LGL		94520
								REV. 1

2017-140



(01) HOOP

NOTES:

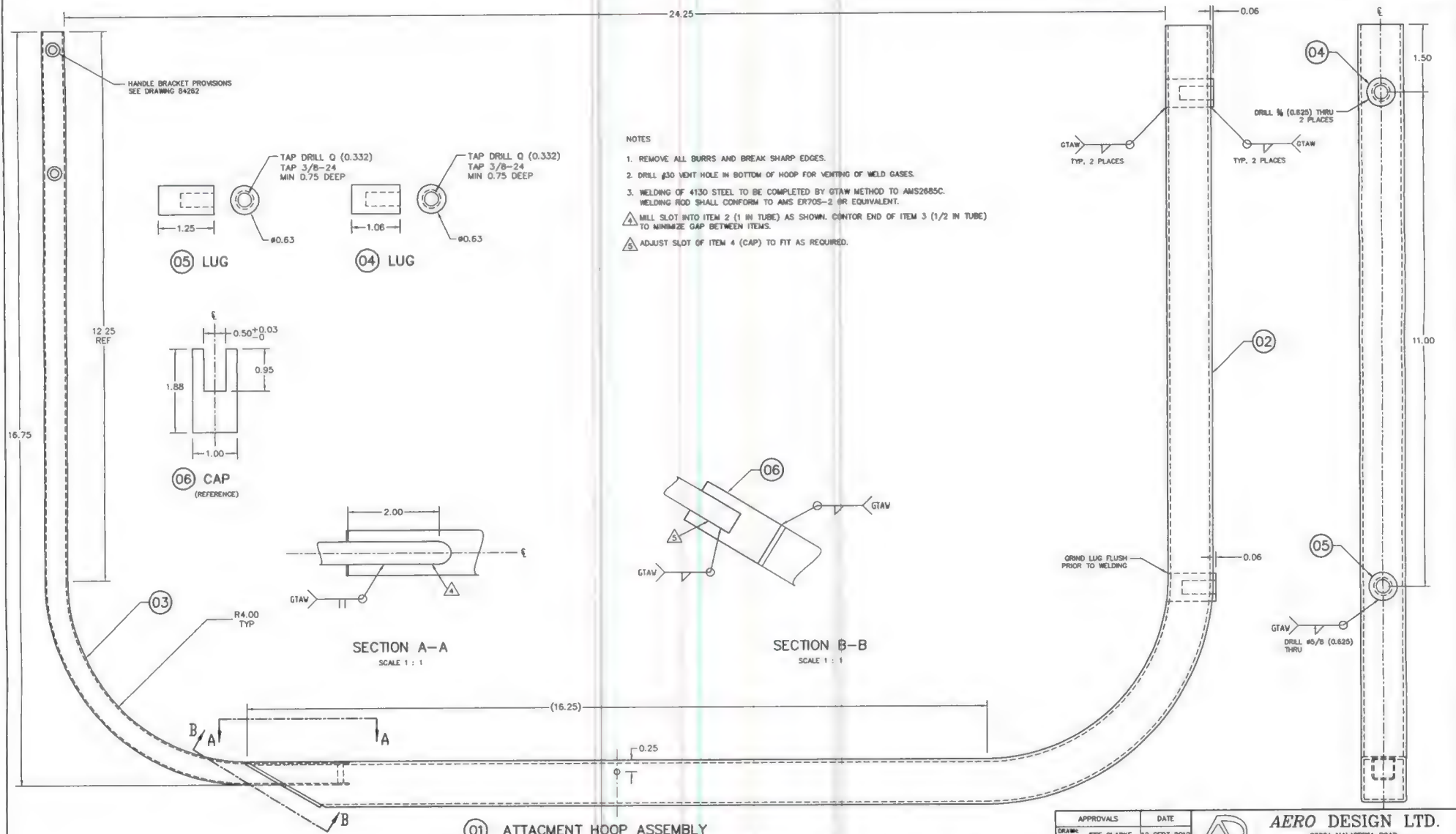
1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

	94520-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
NOTICE THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 260-8087 fax: (403) 260-8333 www.aerodesign.ca		
	DRAWN: JEFF CLARKE		13 SEPT 2011			
	CHECKED: E. BURGOIN					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET HOOP		
	SCALE 1 : 5			DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1			LGL	94520	0	

2017-140

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
01	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; HANDLE PROVISIONS ADDED	BUC	20 FEB 2014



QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	84262-01	01	ATTACHMENT HOOP ASSEMBLY	1018 MILD STEEL	AMS 1010/1020	0.032-0.050 SHEET
1	78423-04	04	LUG	1018 MILD STEEL	AMS 1010/1020	5/8 DIA ROD
1	95926-05	05	LUG	1018 MILD STEEL	AMS 1010/1020	5/8 DIA ROD
1	95926-04	04	LUG	1018 MILD STEEL	AMS 1010/1020	5/8 DIA ROD
A/R	95926-01	01	ATTACHMENT HOOP ASSEMBLY	4130 STEEL COND. N	MIL-T-6736	1/2 X 0.035 SQR TUBE
A/R	95926-01	01	ATTACHMENT HOOP ASSEMBLY	4130 STEEL COND. N	MIL-T-6736	1 X 0.065 SQR TUBE

APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: JEFF CLARKE	12 SEPT 2012	9886A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 604-685-8979 www.aerodesign.ca	
CHECKED: E. BURDON	10 NOV 2012	BELL 429 QUICK RELEASE CARGO BASKET ATTACHMENT HOOP FABRICATION	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		SCALE 1:1	DWG. NO. 95926
DECIMALS ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES ±1/2°	REV. 1
SHEET 1 OF 1			

REV. 0 DESCRIPTION OF CHANGE CREATED FROM 94522, REV. 0 INITIALS DATE

01 END HOOP
LH SHOWN, RH OPPOSITE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	95925-03	03	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
1	1	95925-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 ROD
		95964-01-02	01	LH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
		95964-01-01	01	RH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

APPROVALS	DATE
DRAWN: JEFF CLARKE	20 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

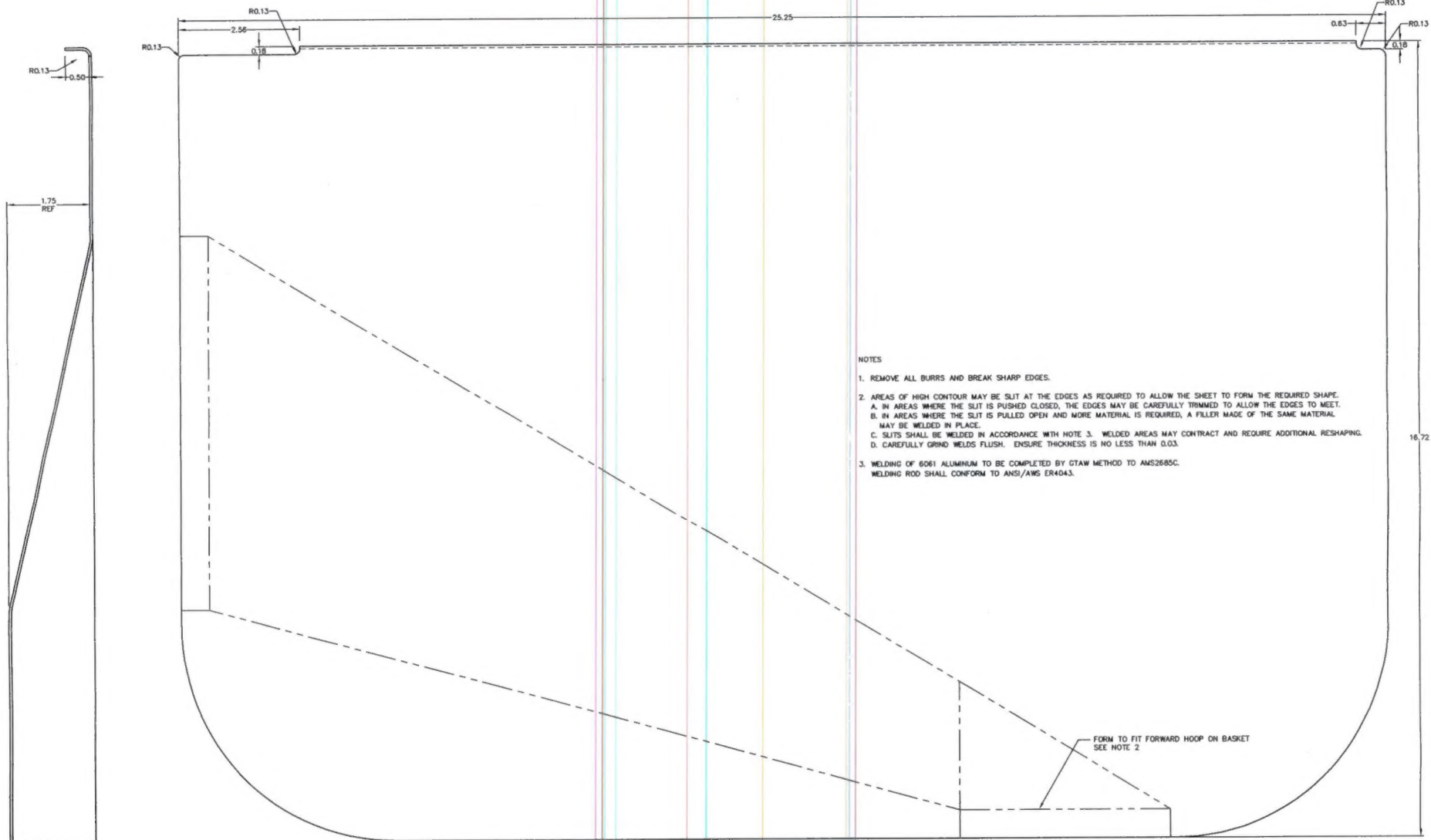
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BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD ATTACHMENT HOOP

SCALE 1 : 5
SHEET 1 OF 1
LGL 95964 0

2017-140

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		




NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. AREAS OF HIGH CONTOUR MAY BE SLIT AT THE EDGES AS REQUIRED TO ALLOW THE SHEET TO FORM THE REQUIRED SHAPE.
 - A. IN AREAS WHERE THE SLIT IS PUSHED CLOSED, THE EDGES MAY BE CAREFULLY TRIMMED TO ALLOW THE EDGES TO MEET.
 - B. IN AREAS WHERE THE SLIT IS PULLED OPEN AND MORE MATERIAL IS REQUIRED, A FILLER MADE OF THE SAME MATERIAL MAY BE WELDED IN PLACE.
 - C. SLITS SHALL BE WELDED IN ACCORDANCE WITH NOTE 3. WELDED AREAS MAY CONTRACT AND REQUIRE ADDITIONAL RESHAPING.
 - D. CAREFULLY GRIND WELDS FLUSH. ENSURE THICKNESS IS NO LESS THAN 0.03.
3. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AWS2685C. WELDING ROD SHALL CONFORM TO AWS/AWS ER4043.

01 FORWARD SHEET
RH SHOWN, LH OPPOSITE

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		95965-02	01	FORWARD SHEET (LEFT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET
		95965-01	01	FORWARD SHEET (RIGHT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET
LIST OF MATERIALS							

APPROVALS		DATE	
DRAWN: JEFF CLARKE		10 APR 2014	
CHECKED: JASON REKVE			
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DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
SCALE 1: 1		DWG. SIZE	
SHEET 1 OF 1		A1	
		95965	
		0	

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BELL 429 -- S/N 57081 & SUB.	
QUICK RELEASE CARGO BASKET	
FORWARD SHEET	



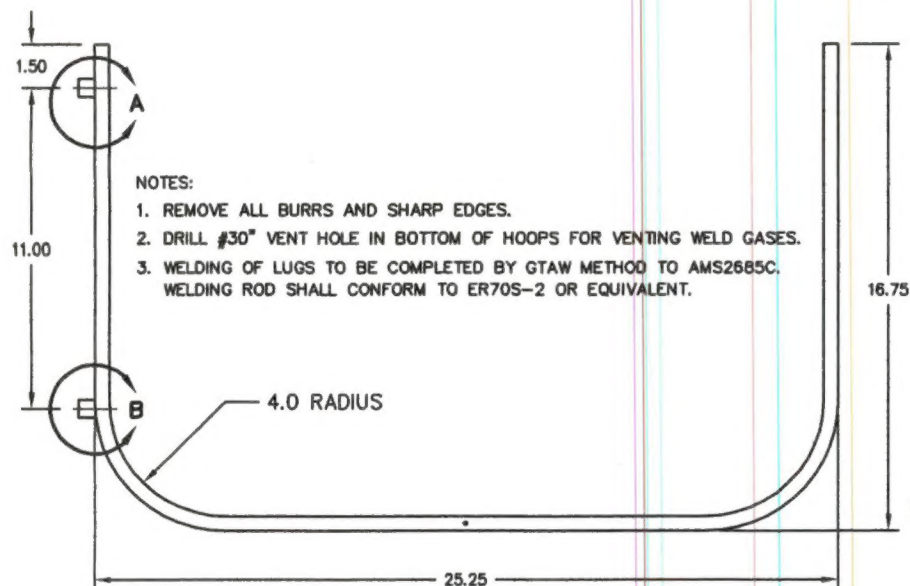
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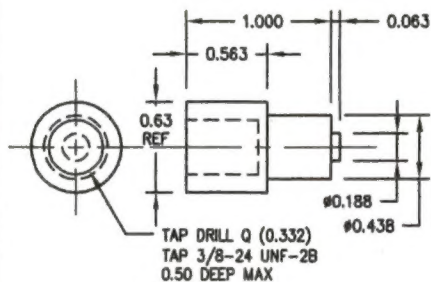
BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD SHEET

2017-140

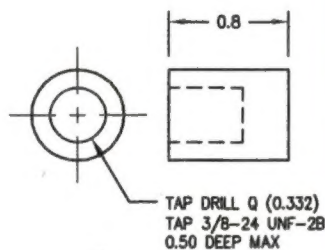
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
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1	TITLE BLOCK UPDATED	BJC	20/02/2014



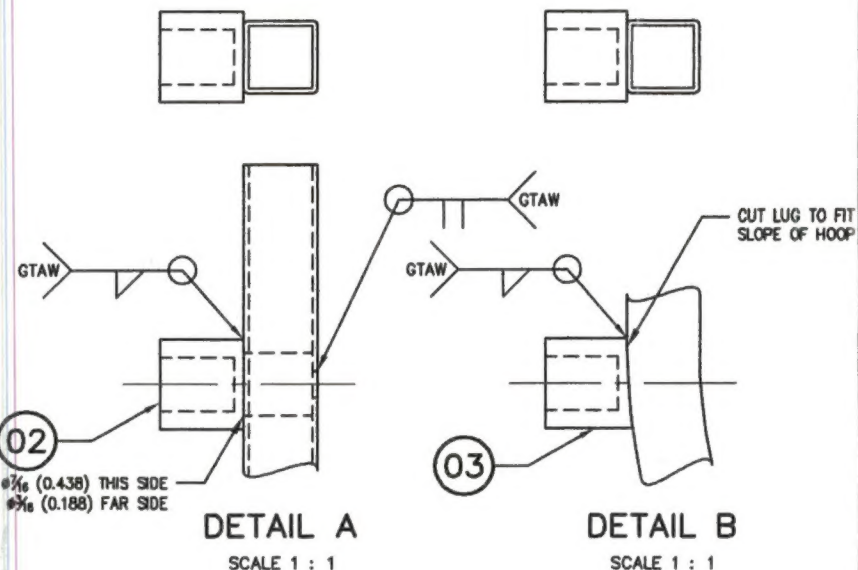
(01) FORWARD HOOP



(02) LUG



(03) LUG



DETAIL A

SCALE 1 : 1

DETAIL B

SCALE 1 : 1

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	95925-03	03	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 ROD
1	95925-02	02	LUG	1018 MILD STEEL	ISI 1010/1020	5/8 ROD
1	95925-01	01	FORWARD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

LIST OF MATERIALS

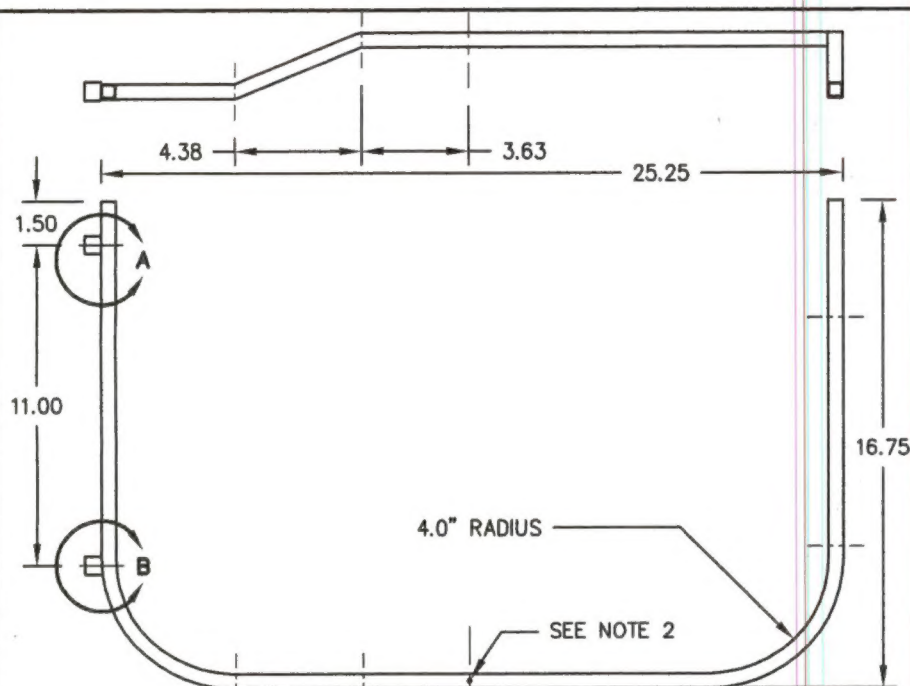
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CHECKED: E. BURGAIN	10 NOV 2012

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DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

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BELL 429 - S/N 57001 THRU 57080 QUICK RELEASE CARGO BASKET FORWARD ATTACHMENT HOOP			
SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	LGL	95925	1

2017-140

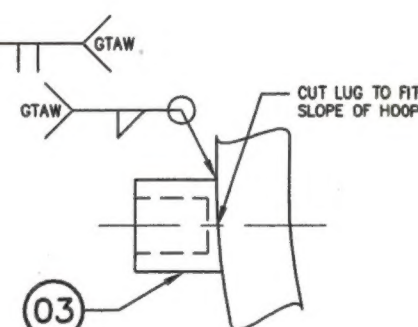
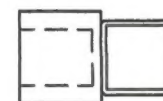
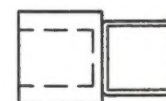


01 END HOOP
LH SHOWN, RH OPPOSITE

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 94522, REV. 0		



DETAIL A
SCALE 1 : 1

DETAIL B
SCALE 1 : 1

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1	95925-03	03	LUG	1018 MILD STEEL	AMS 1010/1020	5/8 ROD
1	1	95925-02	02	LUG	1018 MILD STEEL	AMS 1010/1020	5/8 ROD
		95964-01-02	01	LH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
		95964-01-01	01	RH FWD ATTACHMENT HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	20 FEB 2014
CHECKED: JASON REKVE	



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DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD ATTACHMENT HOOP

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 5	LGL	95964	0
SHEET 1 OF 1			

CARGO BASKET HOOP FABRICATION - 94520

Work Order Number 2017-140

Date: 21 Aug 2017

Volume: 6

General

These instructions apply to cargo basket hoop 94520-01 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

94520, Revision 0 – Hoop (Extra Wide)

Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Instructions

Complete
(initial or SCA)

1. Hoop Fabrication – 94520-01

- a. Cut $\frac{1}{2}$ " x 0.035 material to 53.75", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. Mark tube 11 13/16" from end
- f. Slide stock tube through bending die up align tube marking with 0 mark on bending die. Rotate bending arm clockwise until tube is secure, ready to bend.
- g. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- h. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- i. Repeat steps f. through i. for opposite end of tube.
- j. Check for:
 - i. hoop height: 16.75" (Outside to outside)
 - ii. hoop width just above bends: 25.25" (outside to outside)
 - iii. adjust upper stop for height if required
 - iv. adjust stock length for width if required
 - v. twist – due to pulling bending arm up or down through bend
- k. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
- l. Inspect hoops for conformity to drawing.
- m. Tag complete and inspected hoop(s) and place into stock.

PO #17038

OK